

SPLIT -2

Work Order ID 105394 -2

105394

Page 1

August-01-13 11:30:14 AM

Item ID: D3319-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Forward Wearplate

Start Date: 8/01/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 8/01/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 13-08-07

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3319

C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3319

1010.050

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS

27

8-08-13

13.8.22

1012 0 13-08-22

12 0 13-08-22

12

Work Order ID 105394

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105394

Page 2

Item ID: D3319-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Forward Wearplate
Start Date: 8/01/13 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 8/01/13 Req'd Qty: 10.00 ***10*** Customer:
Reference:
Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Brake NC Brake NC	NC BRAKE Memo 1- Form using DT8326 & DT8261 as per Dwg D3319Rev: 2- Form flat on press using DT8776 block	0.00 0.00				12			8/3/08/2
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00			DAS 27 9-89	12			
160 *160* Large Fab Large Fab	Weld per dwg A/R Hardcoat steel Batch: 124434 Large Fab Memo 1- Layout weld location as per Dwg D3319 using jig D3319-1T3 2- Weld hard surface using DT8755 per QSI 004 and Dwg D3319 Rev: Qty Part Number Description Batch A/R N/A 228/7560 Hardcoat Rod M.124434	0.00 0.00				12			13-8-08

Work Order ID 105394

105394

Page 3

August-01-13 11:30:14 AM

Item ID: D3319-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Forward Wearplate

Start Date: 8/01/13 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 8/01/13 Req'd Qty: 10.00 *10* Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 DAS 16 9-89		13/08/28					
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 DAS 16 9-89		13/08/28					
190 *190* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 12:45 OVEN TEMPERATURE: 320°F FINISH TIME: 1:15	0.00							

1 x 1 m / 13/08/28

m121279

100
100
100

100
100
100

Work Order ID 105394

August-01-13 11:30:14 AM

105394

Page 4

Item ID: D3319-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Forward Wearplate

Start Date: 8/01/13 Start Qty: 10.00 ***10***
 Required Date: 8/01/13 Req'd Qty: 10.00 ***10***

Cust Item ID:
 Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				1			
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: _____ Packaging Memo Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: PPP 100 762	0.00 0.00							
220 *220* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

4B/08/28

MLJ 13-08-28

13-08-28

Picklist Print

August-01-13 11:30:14 AM

Page 1

Work Order ID: 105394

Parent Item: D3319-1

Parent Item Name: Forward Wearplate

Start Date: 8/01/13

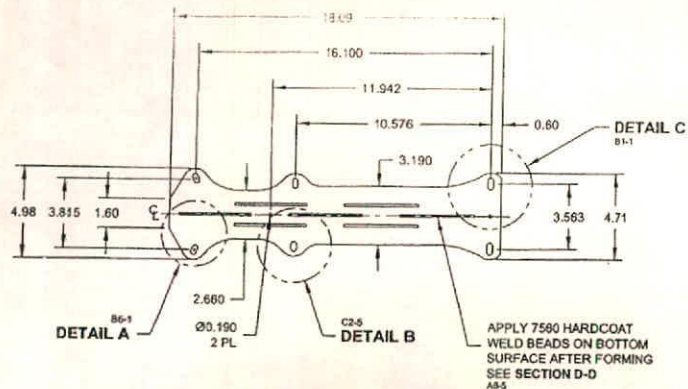
Required Date: 8/01/13

Start Qty: 10.00

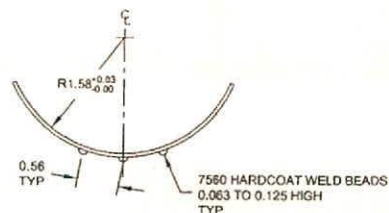
Required Qty: 10.00

Comments: IPP: B05.10.14Added step 9, dwg rev B KJ/EC
IPP Rev:C Now on Waterjet 06-10-26 JLM

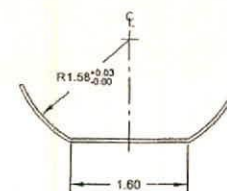
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M1010S18GA 1010/1025 SHEET .048		Purchased	No			100	sf	128.9709	0.628	6610526 7.0		Jn13-08-22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT019		128.970948							
				116268		0.970948							
				117806		18							
				124428		110				124428			



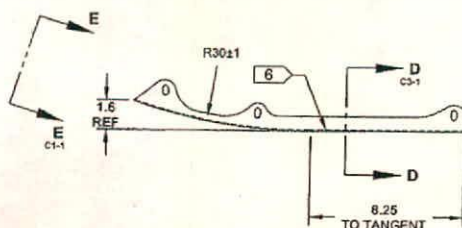
D3319-1F FLAT PATTERN



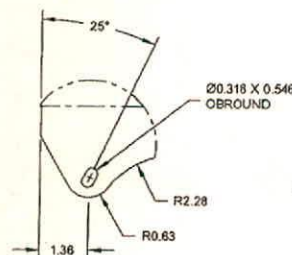
SECTION D-D
SCALE 4X



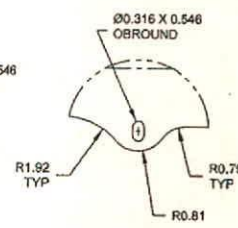
SECTION E-E
SCALE 4X



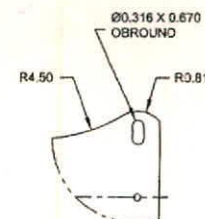
D3319-1 BENDING DETAIL
MAKE FROM D3319-1F



DETAIL A
SCALE 4X



DETAIL B
SCALE 4X



DETAIL C
SCALE 4X

D3319-1 WEARPLATE

NOTES:

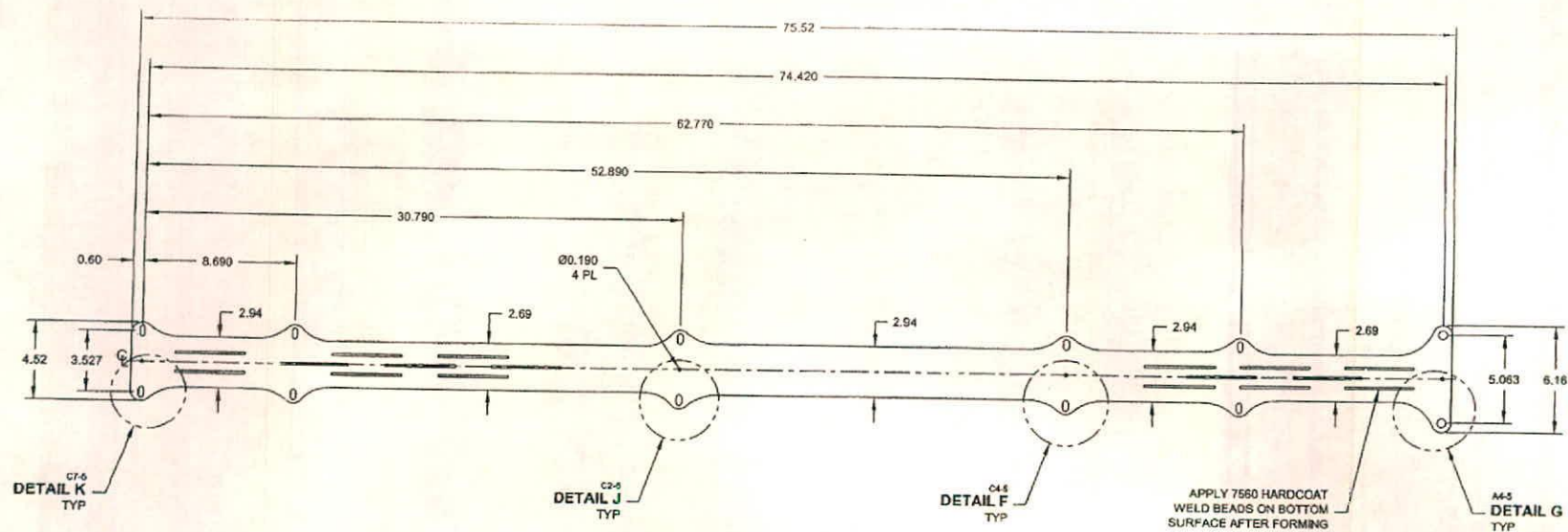
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 0.90 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012-03-16
PER ECN 12-546 02.03.16

C	UPDATE TO CURRENT STANDARDS IAW QSI 043; CLOSED AFT. MOST HOLE ON -3/5-7 (REF DETAIL G). SEE NCR12-547.	MB	12.03.13
B	WIDEN HCLCS, REDUCE WIDTH ON -3/5-7	PH	05.06.06
A	NEW ISSUE	PH	04.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV.
CHECKED	PH	D3319	SHEET 1 OF 4
MFG. APPR.		TITLE	SCALE
APPROVED		WEARPLATE	NTS
DE APPR.			
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105394 MJS
1308-07

105394



D3319-3F FLAT PATTERN



D3319-3 WEARPLATE

D3319-3 BENDING DETAIL

MAKE FROM D3319-3F

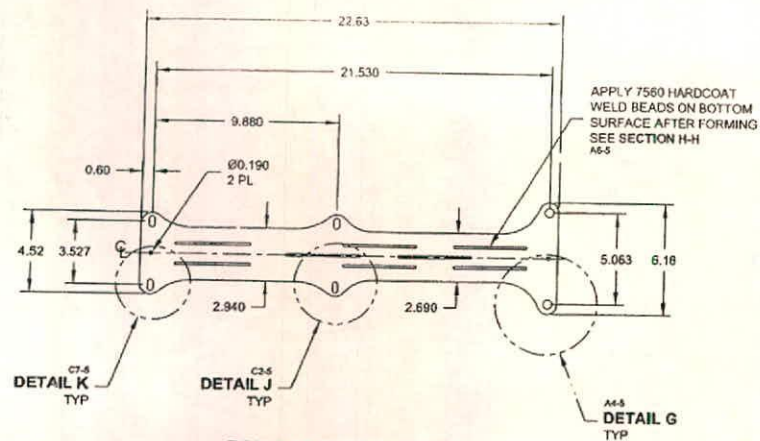
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 3.25 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

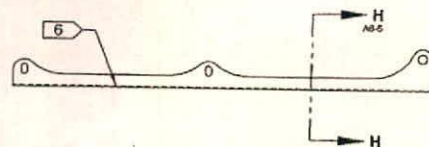
RELEASED
2012 JUL 16
0912 0116

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	J	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV.
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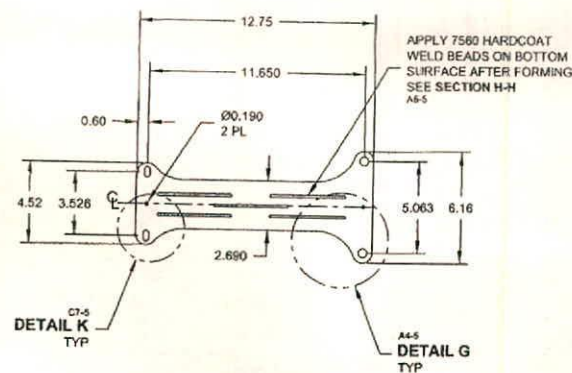
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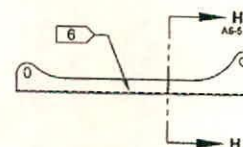
D3319-5F FLAT PATTERN



D3319-5 BENDING DETAIL
MAKE FROM D3319-5F



D3319-7F FLAT PATTERN



D3319-7 BENDING DETAIL
MAKE FROM D3319-7F

D3319-5/7 WEARPLATE

NOTES:

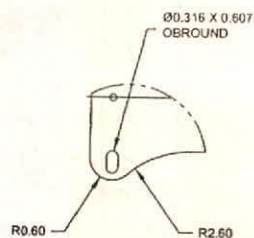
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK) REF. DART SPEC. M1010-S18GA
- 2) FINISH: POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE WITH "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-X B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18" PER DART QSI 046 6.1 (PERMANENT MARKER)
- 7) WEIGHT: D3319-5 = 1.05 lbs APPROX; D3319-7 = 0.60 lbs APPROX
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2012-02-16

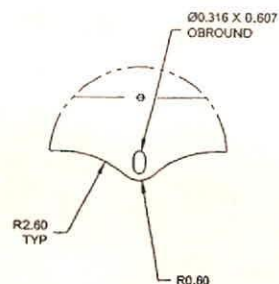
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CHECKED		DRAWING NO.	REV. C
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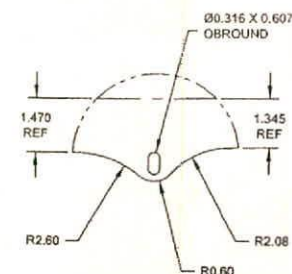
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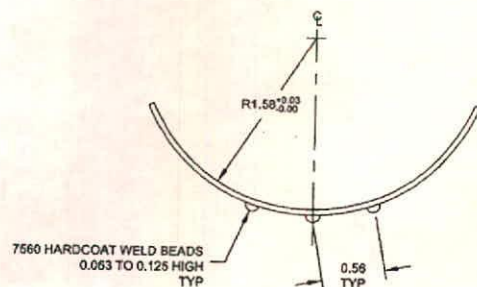
DETAIL K
SCALE 2X
B6-2
C4-3
C9-3



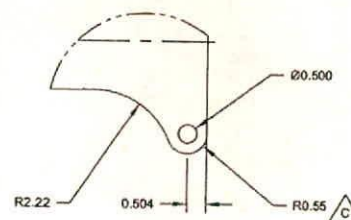
DETAIL F
SCALE 2X
B3-2



DETAIL J
SCALE 2X
B6-2
C7-3



SECTION H-H
SCALE 4X
B4-2
B3-3
B6-3



DETAIL G
SCALE 2X
B6-2
C2-3
C6-3

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